

Date: Friday, 12/7/2007 10:20:50 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT CAP		
Job Number	: 36184		Part Number	: D2646		
Estimate Number	: 10312		Drawing Number	: D2646 REV C		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/7/2007	S.O. No. : N/A	Drawing Revision	: C		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 12/24/2007		
Previous Run	: 33289		Qty:	50	Um:	Each
Written By	:					
Checked & Approved By	:					
Comment	: Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM Est Rev:H Changed Inserts 07-02-19 JLM est rev I changed inserts 07.06.11 EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	PG	PURCHASING
		 Comment: PURCHASING Issue P/O: <u>5243</u> <i>c20712110</i> 1-Spin as per Dwg D2646 2-Material release note required
2.0	D2646P	Aft Cap
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) AFT CAP
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK
		 Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D2646
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.

2-Open holes to .297 as per Dwg D2646.

P88

SAD 07-12-27 \$49

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D36184 PAR #: WIA Fault Category: Prod / Fab. Ass ^{redundant} NCR: Yes No DQA: 1 Date: 01.01.08
 QA: N/C Closed: 1 Date: 08.01.08

NCR: <u>36184</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-12-27	5.0	1 part scrapp. 4 holes drilled in the cap.	<u>1</u>	Scrap: destroy	<u>SRB</u> <u>07-12-27</u>	<u>1</u>	<u>07-12-27</u>	<u>1</u>
		RC: Human error	<u>QSIWZ</u>				<u>QSIWZ</u>	<u>07-12-27</u>

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 36184

Part Number: D2646

Job Number:



Seq. #: Machine Or Operation:

Description :

3-Deburr

6.0 QC5

INSPECT WORK TO CURRENT STEP



12-27 49



Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



49

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL 08-01-04

8.0 POWDER COATING

POWDER COATING



M106379



49X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 08/01/05

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



49



49

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-07

49

10.0 ALS71032130

Insert



49X

Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

INSERT

Batch:

M105729

M-1 08/02/07

49

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



49X

Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

M-1

08/01/07

49

12.0 QC5

INSPECT WORK TO CURRENT STEP



49

Comment: INSPECT WORK TO CURRENT STEP

08/01/07

49

13.0 PACKAGING 1

PACKAGING RESOURCE #1



49X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

M-1

08/01/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/7/2007 10:20:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 36184

Part Number: D2646

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



49

Comment: FINAL INSPECTION/W/O RELEASE

12/08/07/08

Job Completion



2008/1/18

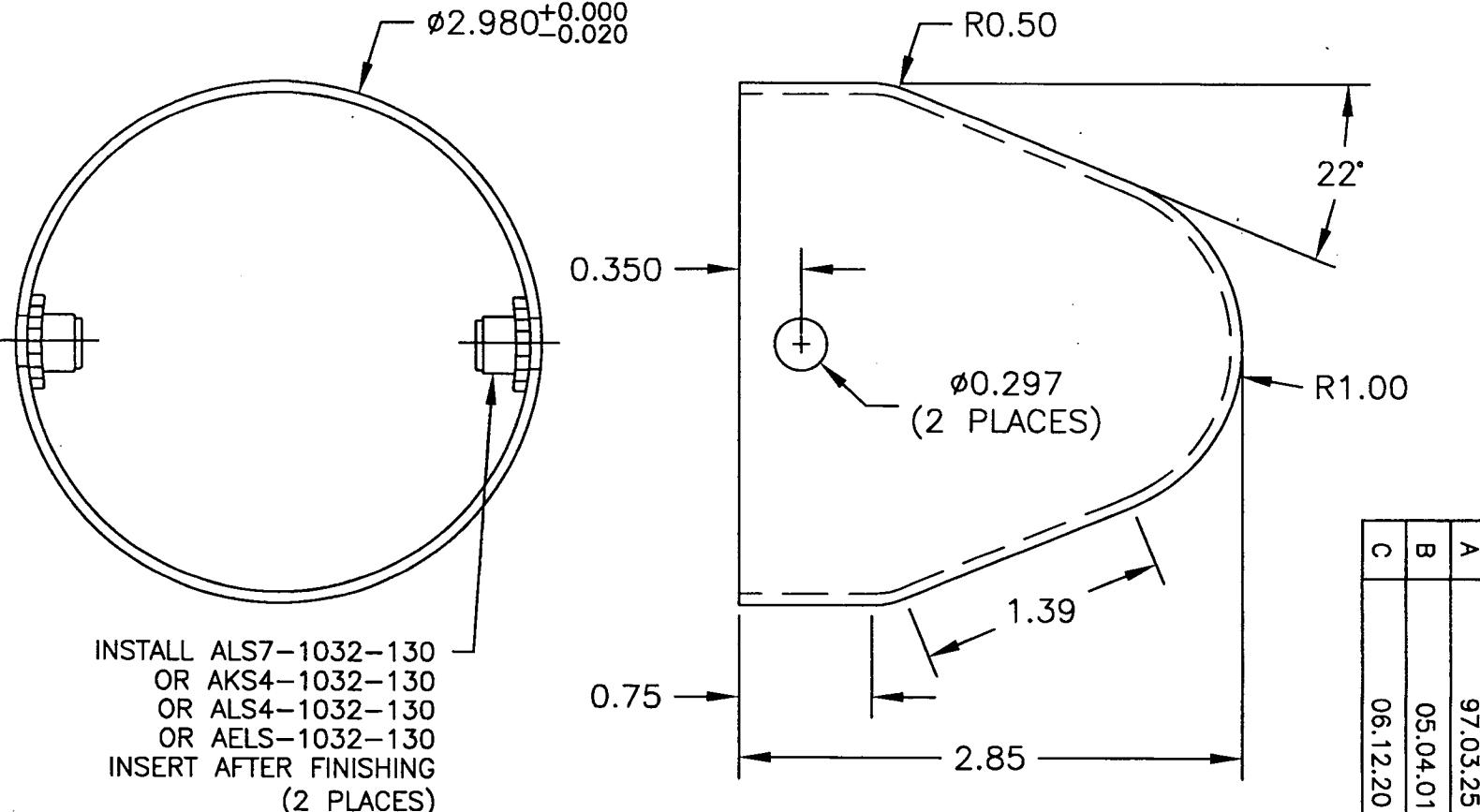
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

INSTALL ALS7-1032-130
OR AKS4-1032-130
OR ALS4-1032-130
OR AELS-1032-130
INSERT AFTER FINISHING
(2 PLACES)

D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NOT SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 360184

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
DS	APPROVED	PORT HADLOCK, WA
CHECKED	REVISION	DRAWING NO.
	<i>PH</i>	D2646
DATE	<i>PH</i>	TITLE
06.12.20		AFT CAP
A	97.03.25	SCALE
B	05.04.01	1:1
C	06.12.20	SHEET 1 OF 1
		RELEASED
		07.02.12 <i>PH</i>

sm

Sieg's Manufacturing Ltd.
6236 205 street, Langley BC, V2Y 1N7.
Phone: (604) 530-7455 Fax: (604) 530-7490

Packing Slip

Packing Slip No.: 34753
Date: 12/18/2007
Page: 1

Sold to:	Ship to:
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
Order No.: 5243	Sold By: KAULBARS, KALE
Shipped By:	Ship Date: 12/18/2007
Tracking No.:	

Item No.	Unit	Description	Quantity
1	EACH	AFT CAPS D2646P	50
Comment:			

Mr. GERRY



ALCOHOLIC BEVERAGE PRODUCTS

Certification of Test Results

P/N 970200

190381982

EDICIONES

CHIQUITO

ORDER NO	LG5947	PO NO	43-62756
ITEM NO	1	PART NO	
ALLOY	1100	TEMPER	D
GAUGE	0.5300	WIDTH	48.0000 LENGTH 0.0000

CERT NO	1000678296
DATE	4/23/2007
SKID NO	661032
SKID WGT	9,885
PAGE	1 OF 1

LOT: 334171 COIL: B91 ORIGIN: 02361-03

INGOT 31 Fe Cu Mn Ni Cr Si Al Ti
 0718321 0.12 0.42 0.12 0.02 0.01 0.01 0.01 0.01 0.01 0.01 0.01 0.01
 (READ IN ELEMENTAL ORDER)

READ DIRECTIONS ATTACHED

TABLE 11. NUMBER OF STRENGTH TESTS

ONE SEVENTEEN STRENGTHENED 12.50 WEST
HEAD WESTERLY WINDS.

MEAN FIELD STRENGTH (OFFSET = 1.25) 5.3 GPa

PALE VIBRAT SUPERIORIS CORPUS a 271
CAMP. 1855

TAIG BLOOMPTION (6 L. = 2 IN.) 3

AS REPORTED BY PAP

AS REPORTED BY SUPPLIER
NETTARUGGIA COMPANY

ANATOMIC AND PHYSICAL DESCRIPTIONS

ASME SB202-1160-6 LMS 4-2011

1974 1209.05 1209.05

FAX 559-544-1100

11 APR 1999 090100Z APR 1999

10.10 **Quality control.** Unless otherwise indicated, the manufacturer, importer, and distributor shall inspect the specifications described herein, including the specific drawing or letter of the description, and shall make every effort to control contamination of aluminum alloys and neither the use of nor components supplied by the manufacturer of the product.

1324 KRM, 7, LAB SUPERVISOR

Sold to COPPER & BRASS SALES PO: 38C380 Part: Order No.: 37872



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: DEC. 18/07

Customer: DART AEROSPACE

Packing Slip: 34753

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By
<u>D2646P</u>	<u>50</u>	<u>14G/1100</u>	<u>n/a</u>	<u>✓</u>	<u>W.</u>

Notes:

LOOKED GOOD TO ME. WE THE SPECS ARE
THE SAME THIS TIME BUT I HAVE NEW ONES
FOR NEXT TIME.

THANKS KALE

Material Certification Attached: Yes